

Date: Monday, 8/21/2006 2:14:24 PM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 28276  
Estimate Number : 12338  
P.O. Number : N/A  
This Issue : 8/21/2006 S.O. No. : N/A  
Prsht Rev. : NC  
First Issue : N/A Type : MACHINED PARTS  
Previous Run : 27192  
Written By :  
Checked & Approved By :  
Comment : Est Rev: A 06.03.21 New Issue JLM

Drawing Name : PLUG  
Part Number : D3492045  
Drawing Number : D3492 UNDER REVIEW  
Project Number : N/A  
Drawing Revision : UNDER REVIEW  
Material : N/A  
Due Date : 9/5/2006  
Qty: 40 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6R0500 6061-T6 Round Bar .500"



Comment: Qty.: 0.0656 f(s)/Unit Total : 2.6250 f(s)  
6061-T6 Round Bar .500"  
(M6061T6R500)  
Batch: M60421

J.F. 06/08/29 43

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA634 & Dwg D3492  
Dwg Rev: A  
Folio Rev: A

J.F. 06/08/29 43

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/08/29 43

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.F. 06/08/29 43

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

J.F. 06.08.21 42

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 8/11/02

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 8/21/2006 2:14:25 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 28276

Part Number: D3492045

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 06/09/02

(42)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3  
(Flat End Only)

a.m. 06/09/02

(12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 11 01

(42)

9.0

NAS1611003

O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s)

Qty Part Number Description Batch

1 NAS1611-003 O-RING

M101519

NAS1611-005 PH  
P.T.O. 06.05.21

a.m. 06/11/02

(43)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Hand Finishing

2-Assemble O'Ring as per Dwg D3492 Applying some O'Ring Lube  
A/R 55-O'Ring Lube Batch: M 101223

a.m. 06/11/02

(43)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

M 06 11 02

(42)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

a.m. 06/11/02

(42)

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/11/02

(42)

U 06/11/01

| W/O:     |      | WORK ORDER CHANGES  |                                      |      |     |                                 |                          |  |
|----------|------|---|--------------------------------------|------|-----|---------------------------------|--------------------------|--|
| DATE     | STEP | PROCEDURE CHANGE  | By                                   | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |  |
| 06.03.21 | 9    | CHANGE NAS1611-003 O-RING TO NAS1611-005 O-RING<br>PERMANENT CHANGE.<br>DWG updated after DIS-751 is complete | RH<br>06.03.21<br>per<br>QSS<br>0-12 |      |     |                                 |                          |  |
|          |      |   |                                      |      |     |                                 |                          |  |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

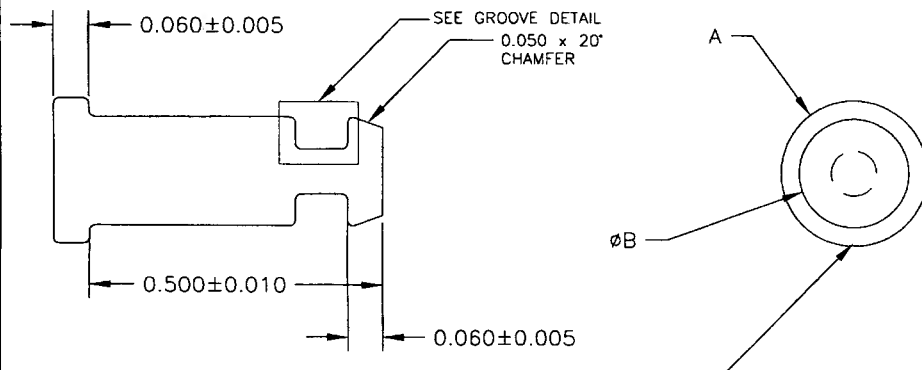
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

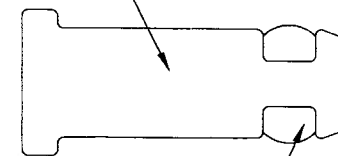
NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



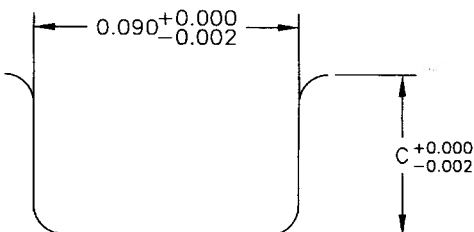
D3492-1/-3/-5 PLUGS IN ACCORDANCE WITH TABLE 1

D3492-1/-3/-5 PLUG IN ACCORDANCE WITH TABLE 2



NAS1611-003/-010/-013 O-RING IN ACCORDANCE WITH TABLE 2

**D3492-041/-043/-045 PLUG ASSEMBLY**



GROOVE DETAIL

**TABLE 1 D3492-1/-3/-5/-7 PLUG DIMENSIONS**

| P/N     | A     | B     | C     | MATERIAL SPEC |
|---------|-------|-------|-------|---------------|
| D3492-1 | 0.500 | 0.394 | 0.055 | M6061T6R0.500 |
| D3492-3 | 0.625 | 0.582 | 0.045 | M6061T6R0.625 |
| D3492-5 | 0.375 | 0.188 | 0.045 | M6061T6R0.250 |

**D3492-1/-3/-5 PLUG NOTES**

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-O PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6RD.DDD)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTE
- 5) BREAK ALL SHARP CORNERS 0.010 MAX

**D3492-041/-043/-045 PLUG ASSEMBLY PARTS LIST**  
(TABLE 2)

| Qty -041 | Qty -043 | Qty -045 | Part Number | Description   |
|----------|----------|----------|-------------|---------------|
| X        |          |          | D3492-041   | PLUG ASSEMBLY |
|          | X        |          | D3492-043   | PLUG ASSEMBLY |
|          |          | X        | D3492-045   | PLUG ASSEMBLY |
| 1        |          |          | D3492-1     | PLUG          |
|          | 1        |          | D3492-3     | PLUG          |
|          |          | 1        | D3492-5     | PLUG          |
|          |          | 1        | NAS1611-003 | O-RING        |
| 1        |          |          | NAS1611-010 | O-RING        |
|          | 1        |          | NAS1611-013 | O-RING        |

USE  
NAS1611-005  
PH

06-03-21

**UNDER REVIEW**

06-03-21 PH

-045 PLUG NEEDS  
NAS1611-005 O-RING

OK  
For  
B28276

**RELEASED**

06-02-07 PH

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 28276

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|         |          |             |
|---------|----------|-------------|
| A       | 06.01.04 | NEW ISSUE   |
| DESIGN  | PH       | DRAWN BY PH |
| CHECKED | #        | APPROVED #  |
| DATE    | 06.01.04 | TITLE       |
|         |          | D3492       |
|         |          | PLUG        |
|         |          | SCALE       |
|         |          | NTS         |

**DART** DART AEROSPACE USA, INC.  
PORT HADLOCK, MA

DRAWING NO. D3492 REV. A SHEET 1 OF 1

